

DART
AEROSPACE
S010945

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Light Lid Assembly, Long Basket

PART NO: D3915-041

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/17/17

Job No: 167641



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D3915-041
Job Sheet 167641



Part No: D3915-041

Job Qty: 1 ea

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/3/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Large Fab2		O.M.L 17-11-16
100	Large Fab	1 pcs		11/29/17	0.00	3.33	Large Fab 2		O.M.L 17-11-16
110	QC	1 pcs		11/29/17	0.00	0.00	QC9		D 17-11-24
120	QC	1 pcs		11/29/17	0.00	0.00	QC5		D 17-11-24
130	HandFinish	1 pcs		11/29/17	0.00	1.00	HandFinish1		2017-11-24 JSC
140	Large Fab	1 pcs		11/29/17	0.00	3.33	Large Fab 2		17-11-27
150	QC	1 pcs		11/29/17	0.00	0.00	QC9		D 17-11-27
155	QC	1 pcs		11/29/17	0.00	0.00	QC6		D 17-11-27
157	HandFinish	1 pcs		11/29/17	0.00	1.00	HandFinish1		17-11-27
160	Powdercoat	1 pcs		11/29/17	0.00	0.83	Powdercoat1		BR 17-11-27
170	QC	1 pcs		11/29/17	0.00	0.00	QC3		17-11-27
180	HandFinish	1 pcs		11/30/17	0.00	0.81	HandFinish4		17-12-11
190	QC	1 pcs		11/30/17	0.00	0.00	QC5		17-12-11
200	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3		17-12-11
210	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		17-12-11

Part Op 100 - 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915

130 - ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***

140 - 1- weld (4) corners. *Batch Rod Alum: M130137*

155 - ***inspect fit of lid with base***

157 - 1- realodine corners ***do not acid etch***

160 - 1- touch up corner with alodine only 2- Plug holes prior to

180 - 1- Install webbing as per dwg 2- Install placard and label as per dwg

M138647 START: 2:25 O.V.T. 3:20 FINISH: 2:55.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2957 F157372	4	18	0	0
	D3915-1 F162730	2	6	0	0
	D4016-5 F152120	3	8	0	0
	D4019-3	3	11	0	0
	D4035-047 F163981	2	2	0	0
	D4056-1	1	8	0	0
180-HandFinish	D2728-1	1	0	0	0
	D4029-041 F157457	1	3	0	0
	MS20600-AD4W4	34	290	0	0

FM138246

NAS1149DN949J

34

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0

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Part Specifications

Specifications could not be found.

Plex 11/3/17 2:44 PM dart.poulin.mario